

ASAP

Dart Aerospace Ltd.

Date: Tuesday, 6/12/2007 3:00:39 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 32889	
Estimate Number : 11125	
P.O. Number : <u>N/A</u>	Part Number : D34033
This Issue : 6/12/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3403 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30989	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 6/15/2007
Checked & Approved By : <u>[Signature] 07.06.12</u>	Qty: <u>100</u> Um: Each
Comment : Est Rev: A 05.08.31 New issue KJ/JLM Est Rev: B 06-03-07 As per Rev B JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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Comment: Qty.: 0.1833 f(s)/Unit Total : 10.9980 f(s)
Material: AISI 303 SS Bar Ø0.750
(M303R0.750)
Identify for D3403-3
Batch: M104128

MS 07/06/13

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1- Turn as per Folio FA558 & Dwg D3403
Folio Rev: B Dwg Rev: B

2-Deburr

MS 07/06/13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/06/13

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 07/06/13

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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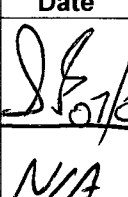

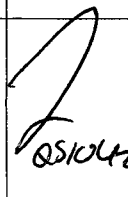



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 97

P= 7/8/22 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-14	2.0	Bushings are 0.002" short on the total length. Program was a	 QS1042	Program was adjusted to correct the length. Parts are acceptable per e-mail.	 N/A	 07-06-18	 QS1042	 070614

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 32889

Part Number: D34033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(128)

Comment: FINAL INSPECTION/W/O RELEASE

RD 5/10/02

Job Completion



CU 7.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

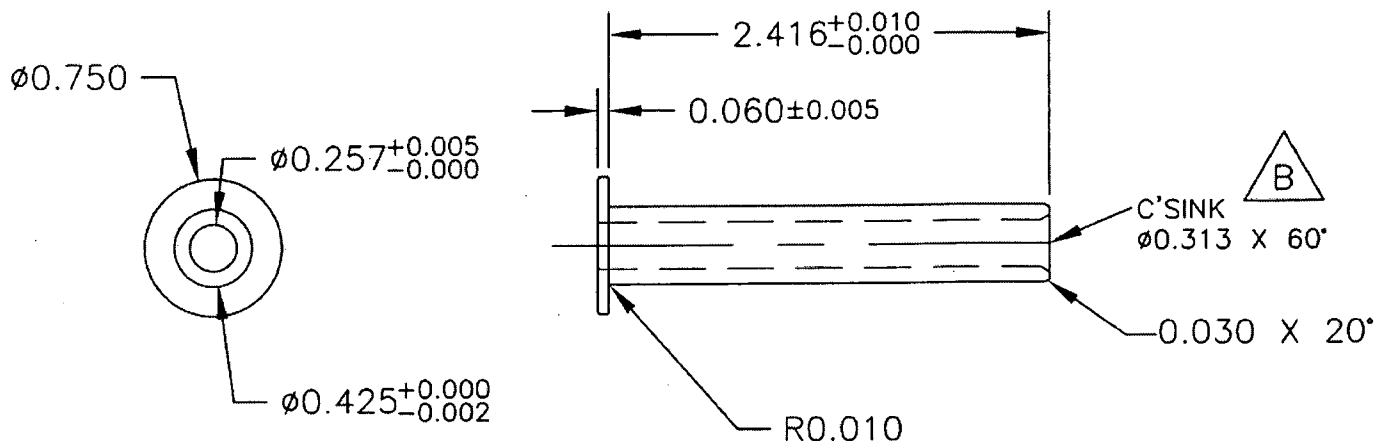
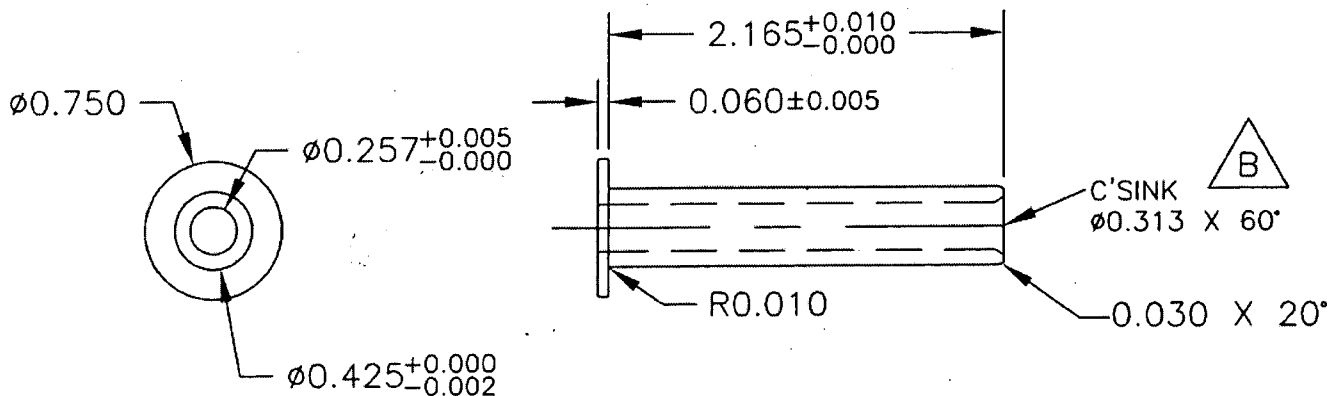
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3403	REV. B SHEET 1 OF 1
DATE 06.01.23		TITLE BUSHING	SCALE 1:1
A	05.03.07	NEW ISSUE	
B	06.01.23	ADD COUNTERSINK	

RELEASED

06.01.27

**D3403-1 BUSHING****D3403-3 BUSHING****D3403-1/-3 BUSHING**

- 1) MATERIAL: 0.750 AISI 303 ROUND BAR (REF. DART SPEC. M303R0.750)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX
- 4) ALL DIMENSIONS ARE INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32889

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L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 15, 2007 10:52 AM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: D3404

Jason,

The D3403-3 bushings that are max 0.002" under size with respect to the 2.165 dimension are acceptable.

David

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, June 14, 2007 8:35 AM
To: 'Jason Murdoch'; 'David Shepherd'
Subject: RE: D3404

I think you mean D340 3

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: June 14, 2007 10:13 AM
To: 'David Shepherd'
Cc: 'L Lacelle'
Subject: D3404

Good morning, I have some D3404 bushings that are 0.002" under size from nominal 2.165 +0.010" -0.000. I think these are still acceptable. The program was modified to achieve the correct dimension for the remainder of the parts. There are 40 bushings that are a max of 0.002" under size. Are these acceptable to you?

jmurdoch@dartaero.com
Q.C. COORDINATOR

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.15/848 - Release Date: 6/13/2007 12:50 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.16/849 - Release Date: 6/14/2007 12:44 PM